



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D212-664-101
Job Sheet 169744



Part No: D212-664-101

Job Qty: 1 ea

Part Name: Fwd Crosstube - High



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/21/17

Job Tracking No:

Due Date: 1/5/18

Created By: Mario Poulin

Type: Stock

Description:

Customer: Ascent Helicopters Ltd (CASCE01)

1550 Springhill Road Parksville, BC, V9P 2Y2 Canada ph:(250) 752-2981 fx:(250) 752-2983.

Note: DWG REV E IPP Rev:E 04.02.16 Reformat KJ/DS IPP Rev:F 06-03-29 Remove Comments on Pick List JLM IPP
Rev:G 07-04-30 As per Rev C JLM IPP Rev:H 11.04.26 inspection strip ecn 11-549 EC verf by:DD IPP REV:I
14.05.27 AS PER ECN 14-570 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	1/4/18	1/4/18	0.00	0.00	Start Up Stores/Pkg-1		GP
110	Packaging	1 pcs	1/4/18	1/4/18	0.00	0.00	Packaging1-3		DP2
120	CNC Bend Crosstubes	1 pcs	1/4/18	1/4/18	3.11	2.22	CNC Bend Crosstube		GP
130	QC	1 pcs	1/4/18	1/4/18	0.00	0.00	QC15		PD 12-12-21
140	Crosstubes	1 pcs	1/4/18	1/4/18	0.00	0.67	Crosstubes-1		DP2
150	HandFXtube	1 pcs	1/4/18	1/4/18	0.00	0.98	HandFinish5		DP2
160	QC	1 pcs	1/4/18	1/4/18	0.00	0.00	QC7-1		38 DAS
165	QC	1 pcs	1/4/18	1/4/18	0.00	0.00	QC5		38 DAS
170	Outsource	1 pcs	1/4/18	1/4/18			SKY002-VC		SP 18-01-10
180	Packaging	1 pcs	1/4/18	1/4/18	0.00	0.00	Packaging2		SP 18-01-10
190	QC	1 pcs	1/4/18	1/4/18	0.00	0.00	QC5		38 DAS
200	SprayPaint	1 pcs	1/4/18	1/4/18	0.00	0.25	Spray Paint		DI 18-01-10
210	QC	1 pcs	1/4/18	1/4/18	0.00	0.00	QC14		38 DAS
220	Crosstubes	1 pcs	1/5/18	1/5/18	0.00	1.69	Crosstubes-1		38 DAS
230	QC	1 pcs	1/5/18	1/5/18	0.00	0.00	QC5		38 DAS
240	Packaging	1 pcs	1/5/18	1/5/18	0.00	0.00	Packaging1-3		38 DAS
250	QC	1 pcs	1/5/18	1/5/18	0.00	0.00	QC4		38 DAS
255	DC	1 pcs	1/5/18	1/5/18	0.00	0.00	DC		38 DAS
260	Packaging	1 pcs	1/5/18	1/5/18	0.00	0.00	Packaging3-1		38 DAS
270	QC21-FG	1 Ea	1/5/18	1/5/18	0.00	0.00	QC21		38 DAS

Part Op 120 - Bend tube as per Dwg D212-664-141 using CNC bender program 212-fw and Folio D212-664-101

Descriptions: 140 - "1-Drill pilot holes in tube as per Dwg D212-664-141 using drill Jig DT8548 & DT8549, using drill table DT8577, set-up towers in hole #7 as per QSI 10 2-Ream hole to finish size in tube as per Dwg D212-664-141 using drill Jig DT8548 & DT8549. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes. 3-Scribe part # and batch # using vibrating stylus as per Dwg D212-664-141 4-*** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-141"

150 - ***IMMEDIATELY AFTER GRINDING***

170 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038 LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order

180 - Ensure copy of NDT results attached to work order.

190 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Inspect for damage & ensure results are as per

DART
AEROSPACE
S031026

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Fwd Crosstube – High

PART NO: D212 – 664 – 101

Revision:

Operation:

Change No:

Outsource

CHG006

Mfg Date: 01/10/18

Job No: 169744

Dwg D212-664-141

200 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** 1-Prime inside & outside crosstube as per QSI 005 4.2 BATCH: 138646 2- After painting remove masking and apply matte clear coat per QSI005 4.2 3- MASK UNDERSIDE OF CROSSTUBE AS SHOWN ON DWG BEFORE PAINTING 4 -Paint Outside of Tube as per Dart QSI 005 4.2 * White paint 138669 Clear 38689

210 - Then, Wrap in plastic bag to protect from scratches

220 - *****LAY DOWN CROSSTUBE ON TABLE AND PUT DT10302 PINS IN SADDLE HOLE FACING UP, USE HOLE IN TAPE MESURE TO PUT IN PINS FOR LOCATING CENTER OF CROSSTUBE. ***** 1- Abrade mating surfaces of support and crosstube with 180 grit sandpaper, clean the area with MEK or equivalent as per dwg 2- Install supports with Proseal 890 per D212-664-141 and QSI 015 A/R Proseal 890 Batch: 138708 EXP: 5/18 PROSEAL CURE TIME 72 HOURS: Start: 18-1-23 Finish: 18-1-26 3- Install clamps with rubber cushion (ENSURE CLAMPS ARE INSTALL ON TOP SIDE OF CROSSTUBE) using DT9565 as per Dwg D212-664-141. ***Torque all clamps to 80-100 IN-LBS.***

230 - ***RE-CHECK TORCQUE ON CLAMP AFTER PROSEAL HAS CURED FOR 72HOURS AS PER DWG.***

250 - ***VERIFY BY _____ BATCH # TO MATCH W/O _____

255 - Photocopy bluefile and create labels as per PPP D212-664-101 CHG006

260 - Identify and pack for shipping as per PPP D212-664-101 Location : FG094

Primer 138646 Clear P.O. 38689 Paint ~~138646~~

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	<u>S017741</u> D212-664-101TRN	1	6	0	0
240-Packaging	<u>FM137371-2</u> AN6-35A - <u>S022728</u>	4	65	0	0
	<u>S017067-2</u> AN6-36A	4	57	0	0
	S017067-2 D3428-1	1	19	0	0
	<u>S016881</u> MS21042L6	6	420	0	0
	<u>FM138040-2</u> NAS1149D0663J	18	1,537	0	0
	<u>D2893-1</u> <u>S032424</u> (3)				
	<u>D3595-063-050</u> <u>S033985</u> (4)				

Part Specifications

MS21920-25 M138441-169 (4)

Specifications could not be found.

Plex 12/21/17 8:14 AM dart.poulin.mario



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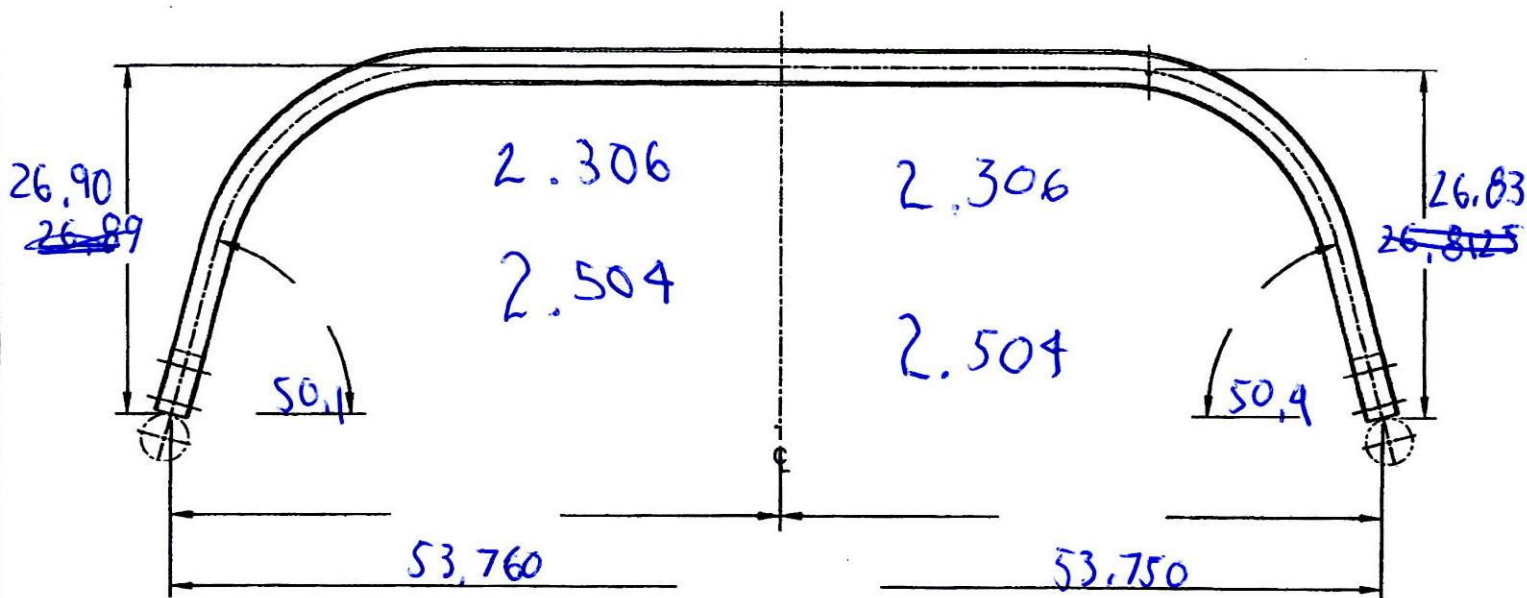
Master Unit 000125

Tel (613) 632-5200

Containers on Master Unit 000125				
Serial No	Part No	Customer Part No	Status	Quantity
S035909	AN6-35A		Allocated	4
S035906	AN6-36A		Allocated	4
S035904	D3428-1		Allocated	1
S035903	MS21042L6		Allocated	6
S035893	NAS1149D0663J		Allocated	18

DART AEROSPACE LTD	Work Order: 169744
Description: Crosstube High Fwd (205/212/412)	Part Number: D212-664-101
Inspection Dwg: D212-664-141 Rev: E	Page 1 of 1

Required Dimension	Min	Max
Height	26.67	27.17
1/2 Span	53.59	53.85
Angle	49	52
Total Span	107.18	107.7
Bending Passes	3	--
Crushing	--	7.2%



	Side A	Side B
Bending Passes	6	6
Crushing	4.1%	4.1%
Comments		

QC15 Inspection	PD
Date	17-12-21

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	08.04.21	Dwg Rev updated	KJ/JM	
C	10.04.01	Dwg Rev updated	KJ	
D	12.04.16	Added bending, crushing dimensions	KJ	
E	14.07.28	Revised max crushing %	KJ	
F	16.01.15	Revised Height min/max dimensions	KJ	

Item	Qty -141	Qty -141B	Qty -141F	Part Number	Description
1	X			D212-664-141	CROSSTUBE ASSEMBLY (206/212/412 HIGH FWD)
2		X		D212-664-141B	CROSSTUBE ASSEMBLY (214 HIGH FWD)
3			X	D212-664-141F	CROSSTUBE ASSEMBLY (205/212/412 HIGH FWD) (ANODIZED)
4	1	1	1	D6005-128	CROSSTUBE
5	2		2	D2893-1	SUPPORT
6	4	4	4	D3595-063-450	RUBBER CUSHION
7		2		D5017-1	SUPPORT
8	4	4	4	MS21920-25	CLAMP (OR MS21920-28)
9	A/R	A/R	A/R	PROSEAL 890 B-2	SEALANT, AMS-S-8802 CLASS B-2

GENERAL NOTES:

- MATERIAL: MANUFACTURED FROM D6005-128
FINISHED LENGTH = 126.514±0.020
- FINISH -141 & -141B: a) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
b) PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
c) MASK UNDERSIDE OF CROSSTUBE AS SHOWN (ZN C8-2 / C8-3, HATCHED AREA)
d) PAINT OUTSIDE PER DART QSI 005 4.2
e) REMOVE MASKING AND APPLY MATTE CLEAR COAT
FINISH -141F: a) ANODIZE PER MIL-A-8625, TYPE II, CLASS 1.
b) ALODINE (DO NOT ETCH) PER QSI 005 4.1.2
c) PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
d) MASK UNDERSIDE OF CROSSTUBE AS SHOWN (ZN C8-2 / C8-3, HATCHED AREA)
e) PAINT OUTSIDE PER DART QSI 005 4.2
f) REMOVE MASKING AND APPLY MATTE CLEAR COAT
*NOTE: BETWEEN FINISHING OPERATIONS EXTREME CARE MUST BE TAKEN NOT TO CONTAMINATE OR DAMAGE FINISHED SURFACES.
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED.
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- IDENTIFICATION: SCRIBE DART PART NUMBER "D212-664-XXX" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS
- WEIGHT: D212-664-141/-141B/-141F = 33.6 lbs
- PART IS SYMMETRIC ABOUT CENTERLINE.
- EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.

MACHINING

- RUN CUTTER OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.

BENDING

- BEND PROGRESSIVELY WITH A MINIMUM OF 3 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 7.2% (BASED ON O.D.) IN LOWER HALF OF R35.5 BEND AND 6% (BASED ON O.D.) ON REMAINING TUBE.
- LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.

ASSEMBLY

- TO INSTALL D2893-1 / D5017-1 SUPPORT: ABRASE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- INSTALL MS21920-25 CLAMPS (OR -28) WITH D3595-063-450 RUBBER CUSHIONS TO SECURE THE SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE ON TOP SIDE OF CROSSTUBE.
- TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.

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2014-05-26

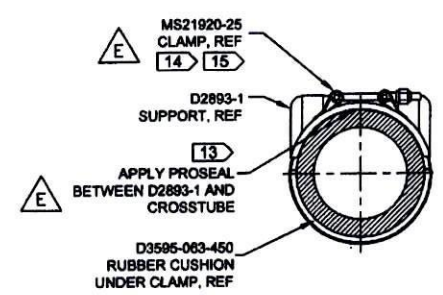
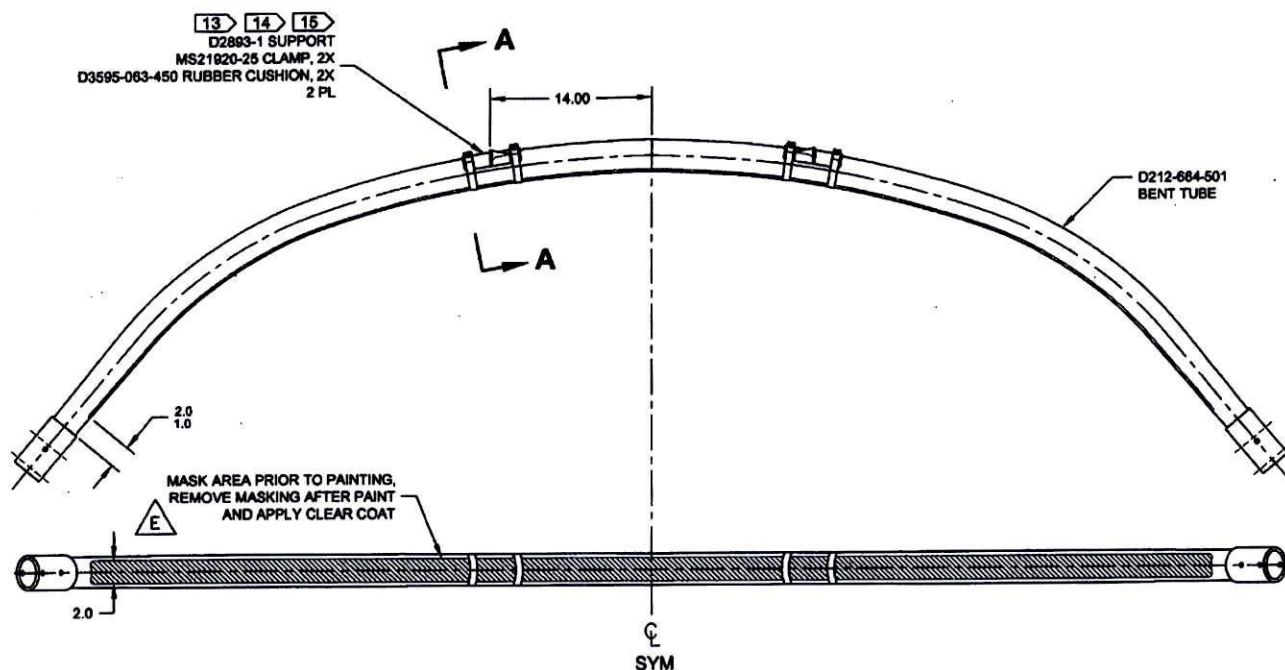
E	ADD -141F, D5017-1 WAS D2893-1 (-141B), PROSEAL WAS MAGNOBOND, NOTE 2: ADD INSPECTION WINDOW, NOTE 11: ALLOW 7.2% CRUSH, NOTE 15: ADD 72HR CURE AND RETORQUE FOR PROSEAL, ADD SHEET 3, CLAMPS REVERSED TO PREVENT CHAFING (B7-2, B7-3), BEND HEIGHT TOL. NOW 0.25 WAS 0.13 (C1-3), INCORP. DEO D-1/2/3	CP	14.04.01
D	REFORMAT/REVISE GENERAL NOTES/PART LIST; REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS; ADD -141B (ZN B4-2, D4-2); REMOVED REF & ADD TOLERANCES (ZN B4-3, C8-3, C8-3 & B6-3); RELOCATED FLAG #6 PER PAR 08-046 (ZN A5-3); MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4	RF	09.09.30
C	REMOVE -351 ABRASION STRIP; ADD MAGNOBOND 6396, CUSHION, REVERSE CLAMPS	PH	07.03.08
B	ADD HOLES FOR COMPATABILITY WITH BHTAA SKIDTUBES	PH	05.02.04
A	NEW ISSUE	CP	00.12.12
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	14.04.01		

DART AEROSPACE LTD
HAWKESSBURY, ONTARIO, CANADA

DRAWING NO. D212-664-141
REV. E
SHEET 1 OF 5
TITLE XTUBE ASSY (205/212/412 HI FWD)
SCALE NTS

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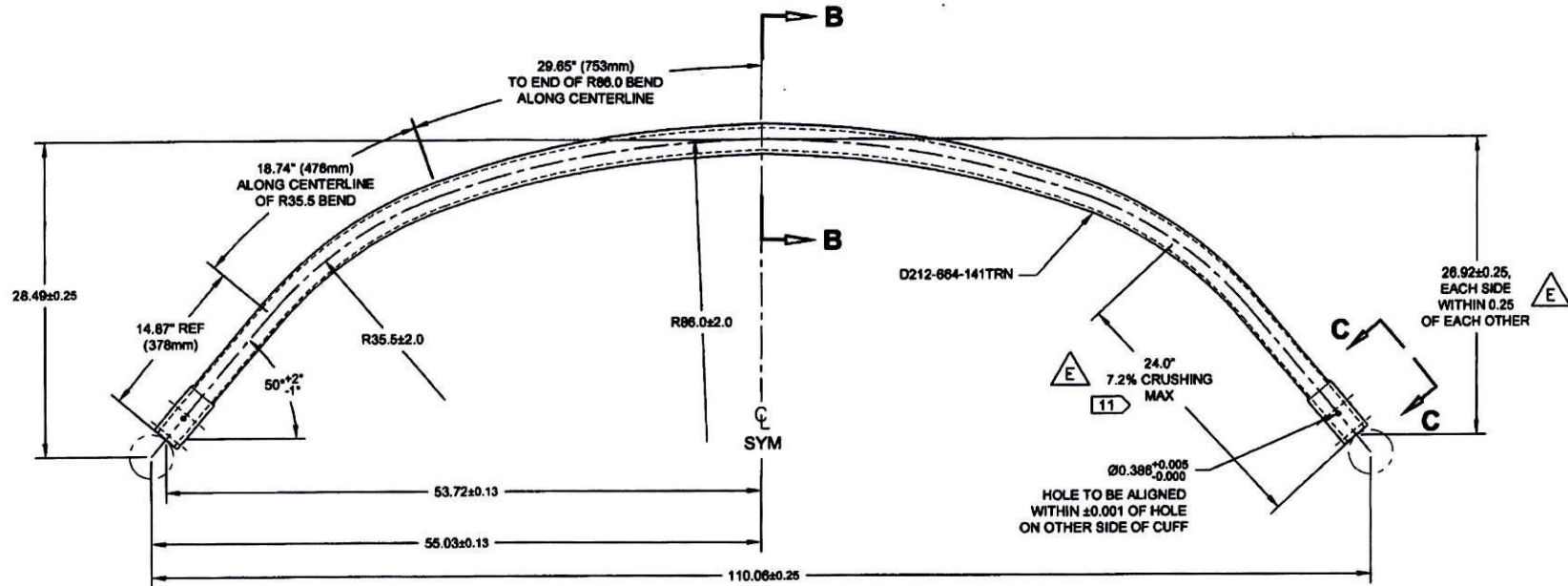
SECTION A-A
SCALE 4X

D212-664-141/-141F
ASSEMBLY DETAIL

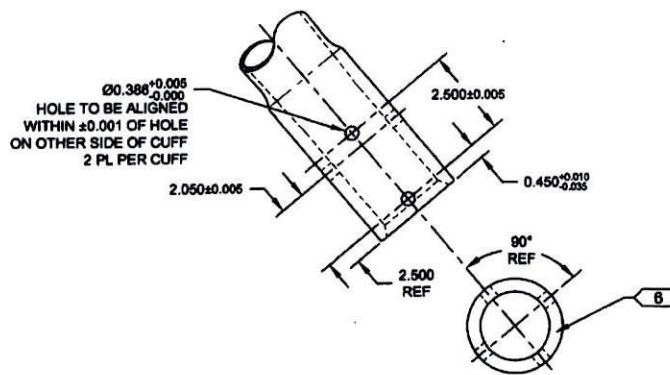
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MFG. APPR.		D212-664-141	SHEET 2 OF 5
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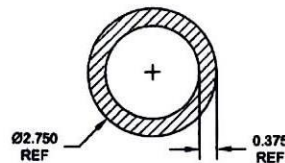
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D212-664-501
BENDING AND DRILLING DETAIL 11



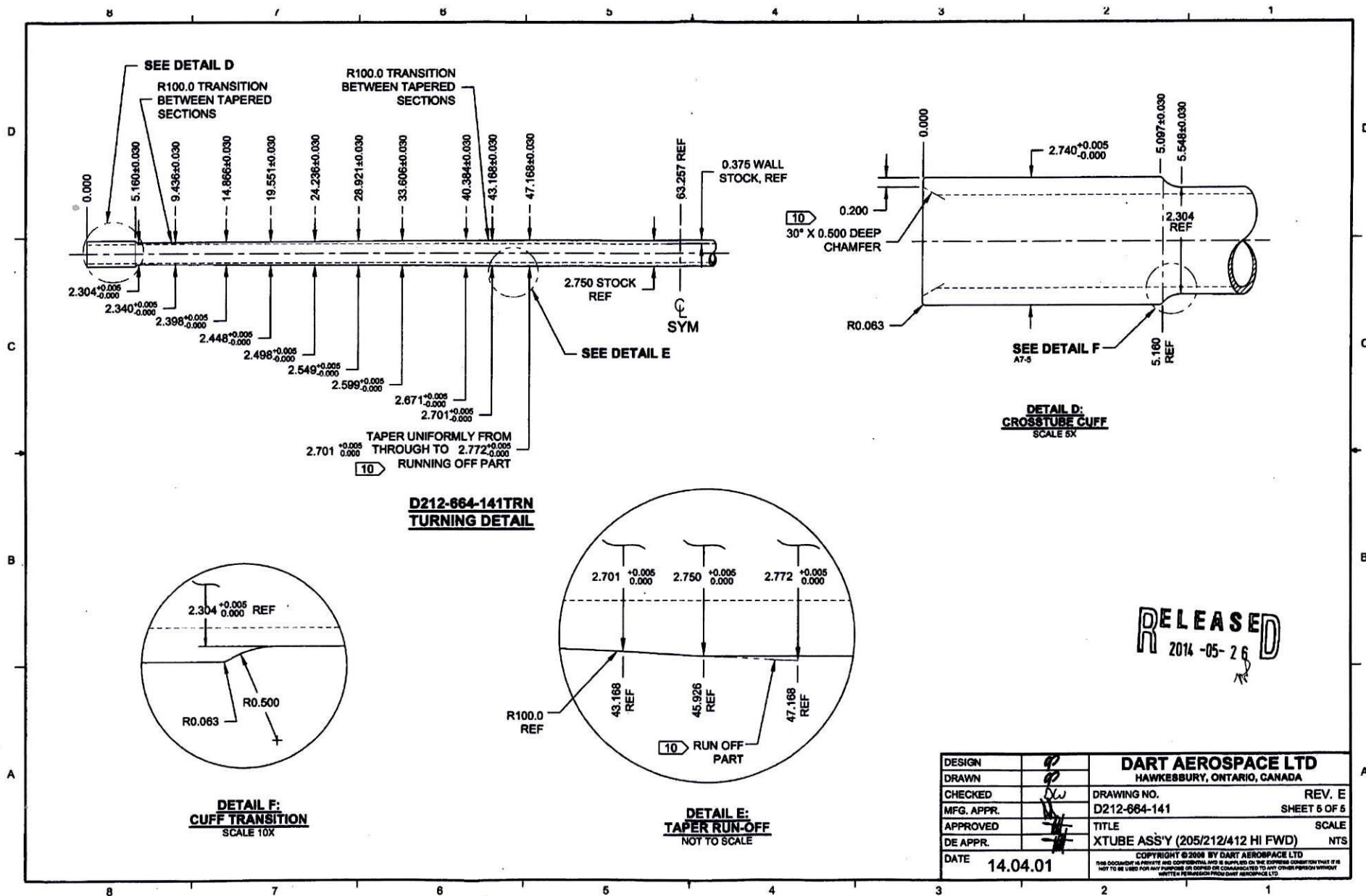
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SECTION B-B
SCALE 4X

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MFG. APPR.	<i>[Signature]</i>	D212-664-141	SHEET 4 OF 5
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Tel (613) 632-5200

PURCHASE ORDER PO038748

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
7	169742	D212-664-101	Penetrant Inspection as per QSI 038 LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order Fwd Crosstube - High *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038 LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	Firmed	1/9/18	1 pcs	0 pcs	1 pcs	\$133.125/pcs	\$133.13
8	169744	D212-664-101	Fwd Crosstube - High *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038 LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	Firmed	1/9/18	1 pcs	0 pcs	1 pcs	\$133.125/pcs	\$133.13
Grand Total:										\$1,065.00

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 1/10/18 10:48 AM dart.baker.diane

**skyservice****Work Order Traveler**

Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO34561	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: PO38748
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:

CARRY OUT NDT INSPECTION (LIQUID PENETRANT) ON 8 CROSSTUBES

ITEM ID: D212-664-101 FWD CROSSTUBE HIGH

1 - WORK ORDER ID#: 169744

2 - WORK ORDER ID#: 169742

3 - WORK ORDER ID#: 169740

4 - WORK ORDER ID#: 169743

5 - WORK ORDER ID#: 168758-A PD

6 - WORK ORDER ID#: 168758

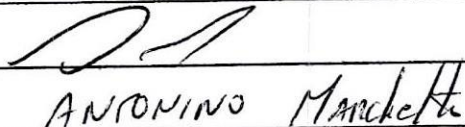
7 - WORK ORDER ID#: 168758-B

8 - WORK ORDER ID#: 168062

8718-01-10

Action Taken:						Date:	Initial/Stamp:
LIQUID PENETRANT INSPECTION CARRIED OUT ON ITEMS LISTED ABOVE (ITEMS 1-8) AS PER ASTM1417M-13						9 JAN 2018	 f
NO CRACK FOUND							
Pen: ZL-27A MWO5678 DEV: SKD-S2 MPO11715 CLEANER: SKC-S MPO13923							
Description	Location	P/N	Qty	Batch	S/N Off	S/N On	

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:			Date:
Name:			9 JAN 2018